

Date: Thursday, 22/05/2008 2:29:17 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 39419	
Estimate Number : 13310	
P.O. Number :	
This Issue : 22/05/2008 S.O. No. :	Part Number : D37931
Prsht Rev. : NC	Drawing Number : PRELIM } A 03.05.23
First Issue : 22/05/2008 Type : R & D SM/MED FAB	Project Number : N/A
Previous Run : 39277	Drawing Revision : PRELIM
Written By :	Material :
Checked & Approved By : 08.05.23	Due Date : 02/06/2008
Comment : Est Rev: A 08-05-13 new issue DD verified by: EC	Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.5733 sf(s)/Unit Total: 11.4660 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 108118 HB 8-5-26

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3793
 Dwg Rev: A
 Prog Rev: A

HB 8-5-26

2-Deburr if necessary HB 8-5-26



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/05/26 (X5)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

08/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/05/2008 2:29:17 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39419

Part Number: D37931

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Joggle on brake using Jig as per Dwg D3793

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

7:30

OVEN TEMPERATURE:

320°

FINISH TIME:

8:00

FL/

08/05/28

(5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

08-05-28

(5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-16

WJ

08-05-28 (5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/29

Job Completion



MF 08-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

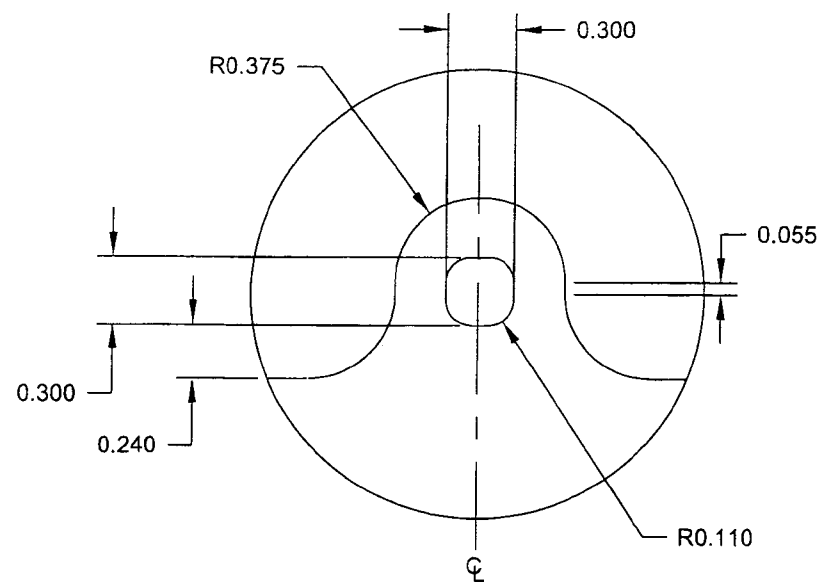
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2

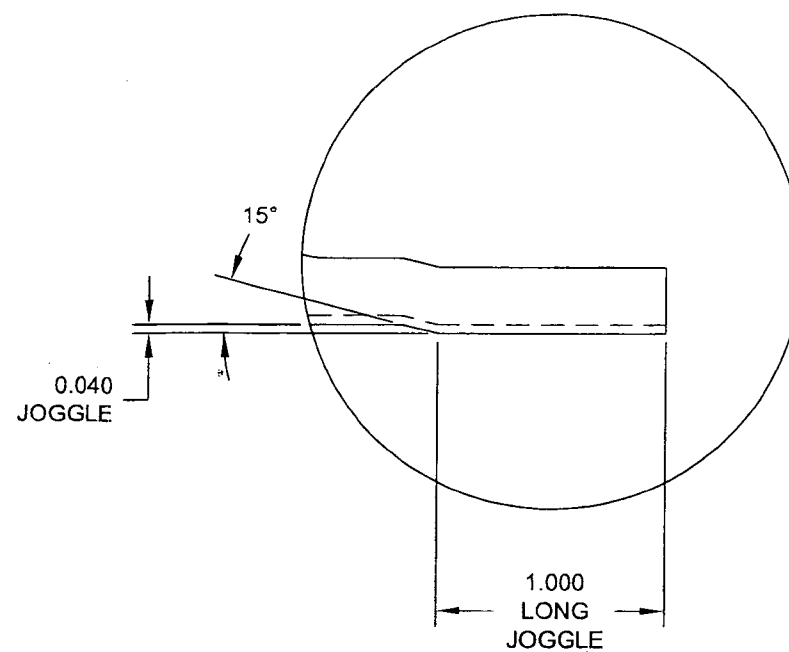
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D

D



DETAIL A
SCALE 10X



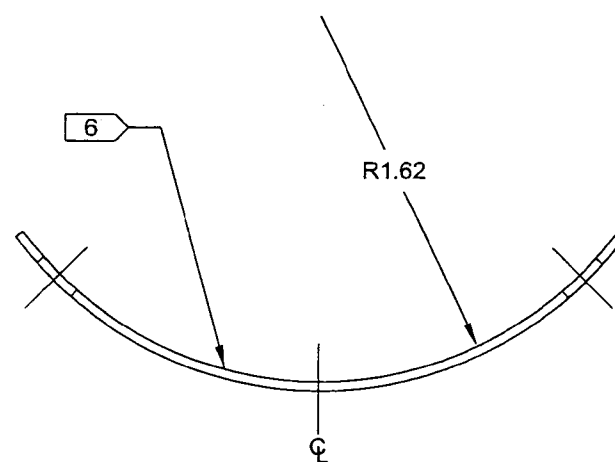
DETAIL B
SCALE 10X

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39419

RELEASED
08-05-23 MJD

B

B



SECTION C-C
SCALE 10X

A

A

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8

7

6

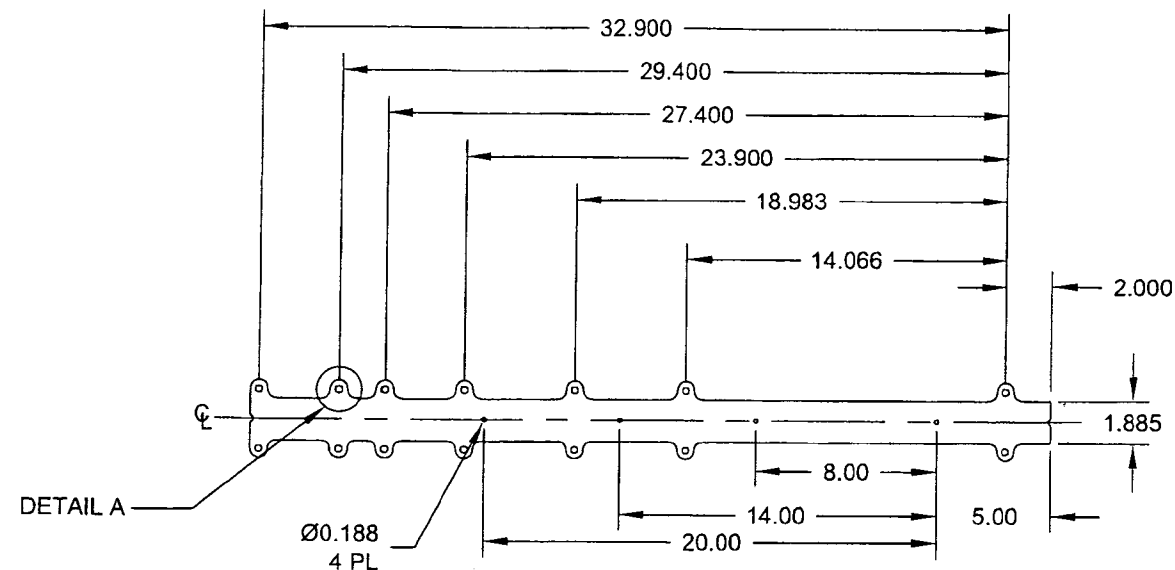
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4

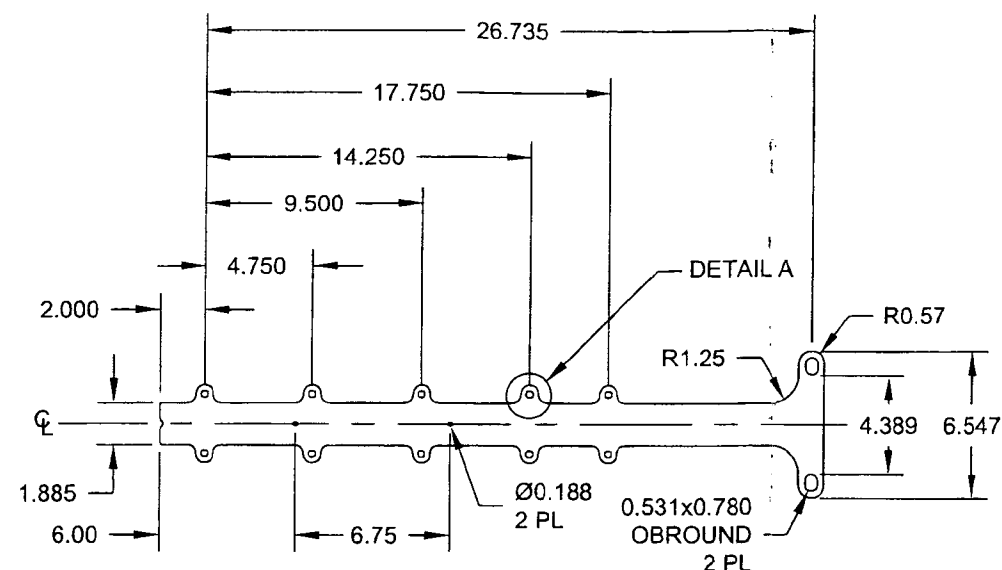
3

2

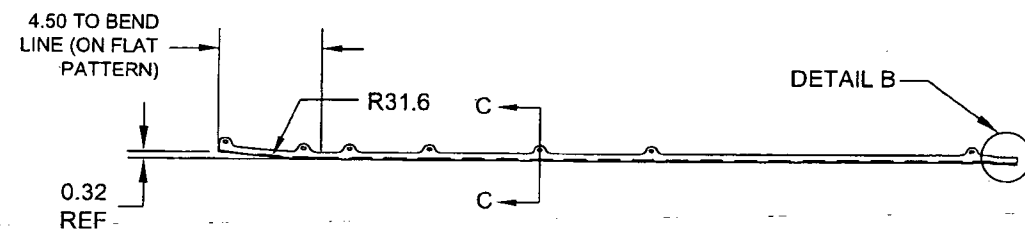
1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

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WITHOUT NOTICE
WORK ORDER
NO. 39419

RELEASED
08.05.14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE	PH	08.05.14
REV.		BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
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